



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2662-2**Job Sheet 187084****Part No:** D2662-2**Job Qty:** 8 pcs**Part Name:** Saddle, LH Fwd, Aft, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/27/18**Job Tracking No:****Due Date:** 12/19/18**Created By:** Jesse White**Type:** SOLD**Description:**

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	8 pcs	12/19/18		0.00	9.92	HAAS - 1		SBL 18/12/08
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	8 pcs	12/19/18		0.00	2.04	Conventional Mill - 1 - B4B		SBL 18/12/08
							Conventional Mill - 2 - B4B		
120	QC 2	8 pcs	12/19/18		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 16		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S135516**Part:** D2662-2**Job No:** 187084**Serial No/Batch:** S135516**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 12/06/18

Plex 11/27/18 12:57 PM dart.white.jesse

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	SPL 18/12/18
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 8 - 12	
					QC 8 - 14	
130 QC 8	8 pcs	12/19/18	0.00 0.00		QC 8 - 16	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mail 18/12/12
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
140 Handfinish - 1-1 Chemical-B4B	8 pcs	12/19/18	0.00 0.23		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 18/12/12
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
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					Handfinish - 1 - 17 - B4B	
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					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	

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				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	8 pcs	12/19/18	0.00 0.24	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	8 pcs	12/19/18	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 16
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 38
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9
170	Packaging 3-1 - Stock - B4B	8 pcs	12/19/18	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
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					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
180	QC 21 - SA	8 pcs	12/19/18	0.00 0.00	QC 21 - SA - 16

BL 18-12-17

DAS

9 18-12-18

9-89

DAS

DEC 20 2018

9-89

DAS

21

9-89

DEC 20 2018

Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number. Inspect part number and batch number are Descriptions: programmed MACHINE AS PER FOLIO FB069 & DWG DWG REV: FOLIO REV:

110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 2:50 OVEN TEMPERATURE: 320°

FINISH TIME: 4:50 2:00 M 138451

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	8 Ea (1 ea)	100-HAAS 4 Axis	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	8	41	0
Part Specifications				
Specifications could not be found.				

Plex 11/27/18 12:57 PM dart.white.jesse

PQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Misidentified ☐	Past Due ☐																				

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621	/	3.616	3.616	3.616	3.616	3.616
B	0.256	0.263	/	0.257	0.257	0.257	0.257	0.257
C	0.315	0.322	/	0.316	0.316	0.316	0.316	0.316
D	2.495	2.505	/	2.500	2.500	2.500	2.500	2.500
E	1.674	1.684	/	1.679	1.679	1.679	1.679	1.679
F	0.100	0.140	/	0.127	0.127	0.126	0.126	0.127
G	0.210	0.230	/	0.223	0.223	0.223	0.222	0.224
H	0.615	0.685	/	0.675	0.675	0.675	0.675	0.675
I	2.470	2.510	/	2.495	2.495	2.495	2.495	2.495
J	1.313	1.343	/	1.322	1.323	1.325	1.324	1.325
K	0.178	0.198	/	0.188	0.188	0.188	0.188	0.188
L	0.470	0.530	/	0.500	0.500	0.500	0.500	0.500
M	1.125	1.145	/	1.138	1.138	1.138	1.138	1.138
N	0.100	0.180	/	0.135	0.135	0.135	0.135	0.135
O	0.100	0.140	/	0.136	0.133	0.133	0.130	0.132
P	0.240	0.260	/	0.254	0.254	0.254	0.253	0.253
Q	0.677	0.697	/	0.687	0.687	0.687	0.687	0.687
R	0.540	0.560	/	0.550	0.550	0.550	0.549	0.549
S	0.912	0.932	/	0.921	0.9215	0.920	0.920	0.920
T	0.787	0.807	/	0.798	0.798	0.797	0.798	0.798
U	5.990	6.010	/	6.000	6.000	6.000	6.000	6.000
V	4.995	5.005	/	5.000	5.000	5.000	5.000	5.000
W	0.490	0.510	/	0.500	0.500	0.501	0.500	0.500
X	0.312	0.319	/	0.313	0.313	0.313	0.313	0.313
Y	0.990	1.010	/	1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255	/	1.250	1.25	1.25	1.25	1.25
AB	0.490	0.510	/	0.500	0.500	0.500	0.500	0.500
AC	3.745	3.755	/	3.750	3.75	3.75	3.75	3.75
AD	0.100	0.140	/	0.130	0.130	0.130	0.130	0.130
AE	0.235	0.240	/	0.239	0.238	0.238	0.238	0.238
AF	0.510	0.515	/	0.510	0.510	0.510	0.510	0.510
AG	0.100	0.120	/	0.110	0.110	0.110	0.110	0.110
AH	1.565	1.585	/	1.578	1.578	1.578	1.578	1.578

DAS Accept/Reject

Measured by: 57	Date: 18/12/08
Audited by: [Signature]	Date: 18/12/12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	
H	12.03.08	Dimension AH added, O revised	KJ	[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>								Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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OTHER :																																																															

DART AEROSPACE LTD			Work Order: 167 084	
Description: 206 Saddle, Inboard, Left side			Part Number: D2662-2	
Inspection Dwg: D2662 Rev: E DSK: Rev:			Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 *	7 2	8 3	9 4	10 5
A	3.611	3.621		3.616	3.616	3.616		
B	0.256	0.263		.257	.257	.257		
C	0.315	0.322		.316	.316	.316		
D	2.495	2.505		2.500	2.500	2.500		
E	1.674	1.684		1.679	1.679	1.679		
F	0.100	0.140		.125	.126	.127		
G	0.210	0.230		.222	.222	.223		
H	0.615	0.685		.675	.625	.625		
I	2.470	2.510		2.495	2.495	2.495		
J	1.313	1.343		1.325	1.325	1.325		
K	0.178	0.198		.188	.188	.188		
L	0.470	0.530		.500	.500	.500		
M	1.125	1.145		1.138	1.138	1.138		
N	0.100	0.180		.135	.135	.135		
O	0.100	0.140		.130	.128	.128		
P	0.240	0.260		.254	.253	.253		
Q	0.677	0.697		.687	.687	.687		
R	0.540	0.560		.549	.550	.550		
S	0.912	0.932		.923	.921	.921		
T	0.787	0.807		.795	.795	.795		
U	5.990	6.010		6.000	6.000	6.000		
V	4.995	5.005		5.00	5.000	5.000		
W	0.490	0.510		.500	.500	.500		
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AC	3.745	3.755		3.750	3.750	3.750		
AD	0.100	0.140		.129	.129	.129		
AE	0.235	0.240		.238	.238	.238		
AF	0.510	0.515		.510	.510	.510		
AG	0.100	0.120		.110	.110	.110		
AH	1.565	1.585		1.578	1.578	1.578		

DAS Accept/Reject

Measured by: 57	Date: 18/12/08
Audited by: 9-89 <i>mmc</i>	Date: 19/12/10
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
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H	12.03.08	Dimension AH added, O revised	KJ	<i>M</i>

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